



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

269T9281
Job Sheet 185221



Part No: 269T9281

Job Qty: 2 ea

Part Name: Wrench, Splined Fitting



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 10/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG 269T9281 REV:1 IPP REV A 18.02.14 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/31/18	10/31/18	0.00	0.00	Start Up Waterjet2		18/10/25
100	Waterjet - B4B	4 pcs	10/31/18	10/31/18	0.08	0.67	Waterjet 2 OMAX		18/10/25
110	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC2 Waterjet-4		18/10/25
120	CNC Vertical Machining	4 pcs	10/31/18	10/31/18	1.00	0.40	MORI NV5000-2		18/11/01
130	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC2 Machining-5		18/11/01
140	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC8 Machining-5		18-11-03
200	Outsource	4 pcs	10/31/18	10/31/18			ME1001-VC Atlantic	21	
230	Outsource	4 pcs	10/31/18	10/31/18			GRO002-VC	10	
240	Packaging	4 pcs	10/31/18	10/31/18	0.00	0.00	Packaging2		NOV 2018
250	QC	4 pcs	10/31/18	10/31/18	0.00	0.00	QC6		38
260	Packaging	4 pcs	10/31/18	10/31/18	0.00	0.00	Packaging3-2		9-00
270	QC21-FG	4 Ea	10/31/18	10/31/18	0.00	0.00	QC21		NOV 20 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio FB AA FOLIO REV: A DWG REV: 1 2-Mill chamfer.
130 - Engrave T/N Using Marktronic engraver as per DWG
200 - HEAT TREAT TO RC 25-32 1--Issue P/O to Meteore; P/O Atlantic RC Atlantic 2-Bead blast 3-
Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Meteore to ship directly to Groupe Altech or
ATG
230 - -Issue P/O to Groupe Altech; PO Atlantic -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE
4 -Certificate of Conformity is required
240 - Receive
260 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NS.250	4130 Sheet .250	12.6440 sf (3.161 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NS.250	13	17	0

271
30
1.1

Part Specifications

Specifications could not be found.

Plex 10/24/18 8:54 AM dart.lacelle.linda



Container No: S121592



Part: 269T9281

Job No: 185221

Serial No/Batch: S121592

Revision: 1

Inspector:

Exp Date:

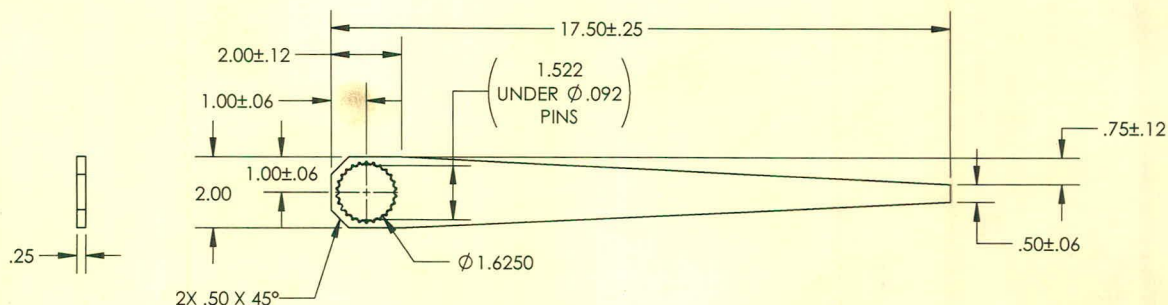
Instructions:

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/25/18

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
	DRAWN FROM TATERED ORIGINAL DRAWING.	6/1/09	RJC	RW
1	CHANGED TOLERANCE IN TITLEBLOCK TO REFLECT ORIGINAL DRAWING.	11/19/11	RJC	RW



WATER JET

SPLINE DATA	
NO. TEETH	26
DIAMETRAL PITCH	16/32
PRESSURE ANGLE	30°
BASE DIA.	1.4073
CIRCULAR PITCH	.1963
PITCH DIA.	1.6250
MAJOR DIA.	1.7350 / 1.7400
MINOR DIA.	1.5600 / 1.5650

RED BARN MACHINE	
WRENCH FITTING	
DWG NO. 269T9281	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .010 .XX ± .03	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .016 ± .48° PR .016 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> REAT TREAT FINISH SPEC	USED ON MODEL
SCALE 1:4	DATE 11/10/2011 SHEET 2 OF 2



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER **PO041630**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041630
PO Date: 11/6/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185602	C45-15	1-Issue P/O to ATLANTIC HEAT TREAT; P/O _____ RC 2-Bead blast 3--Material type; 4140 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO GROUPE ALTECH	Firmed	-	11/16/18	4 pcs	0 pcs	4 pcs	\$40.00/pcs	\$160.00

Line Item Note URGENT **need a day turn over **



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PURCHASE ORDER **PO041630**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	185221	269T9281	Wrench, Splined Fitting HEAT TREAT TO RC 25-32 1--Issue P/O to Atlantic; P/O _____ RC 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	11/16/18	6 pcs	0 pcs	6 pcs	\$35.75/pcs	\$214.50
						NOV 15 2018					DAS 38 9-89
3	177795	RBEM652V3002101-M-7	Stud 1--Issue P/O to Atlantic; P/O _____ RC 35-45 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/16/18	6 pcs	0 pcs	6 pcs	\$35.75/pcs	\$214.50
						NOV 15 2018					
						NOV 15 2018					
Grand Total:											\$589.00



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PURCHASE ORDER PO041630

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 1:57 PM dart.tsimiklis.chrisoula

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Atlantic Heat Treating (2001) Ltd

Order No.: 160245

Ship Date: 9/11/2018

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 157357
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041630 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
	✓ 6PCS MATERIAL 4130 SAND BLAST & HEAT TREAT TO 25-32RC BLACK OXIDE, C OF C, PRT# 269T9281, JOB# 185221 ✓	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 6

Pounds Shipped: 10.00

29 Re^{ts}

11-14-18

Order No.: 160245

Shipped Complete

Quantity Shipped: 6.00

Received By:

Date:

Pounds Shipped: 10.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/09/2018

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Certification

Date: 11/14/2018

Entry Date: 11/09/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041630

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
6	6PCS MATERIAL 4130 SAND BLAST & HEAT TREAT TO 25-32RC BLACK OXIDE, C OF C, PRT# 269T9284, JOB# 185221	10

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

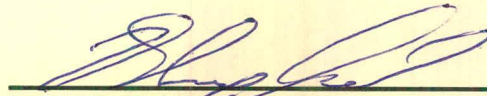
Results:

Harden ROCKWE 25. 32. 29. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 29 RC AS PER CUSTOMER REQUEST

BLACK OXIDE AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

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KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

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